

Work Order ID 129555

129555

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Friday, February 13, 2015 12:39:08 PM

Item ID: D135-751-011 Accept *N900040100* Setup Start *NS1*

Revision ID:

Item Name: Skidtube with Standard Wearplates Fits LH or RH Stop *NS2*

Start Date: 2/13/2015 Start Qty: 1.00 *1* Cust Item ID:

Required Date: 2/13/2015 Req'd Qty: 1.00 *1* Customer:

Reference:

Approvals: Process Plan: MCS Date: 15-02-13 Tooling: _____ Date: _____ Run Start *NR1*

QC: _____ Date: _____ SPC (Y/N): _____ Date: _____ Stop *NR2*

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
Draw Nbr	Revision Nbr								
D3507	Rev D								
DSI 9661	A								
100	Document Control	0.00							
100	DOCUMENT CONTROL								
DC	Memo	0.00							
Doc.Control -USB or Paperwork	Photocopy bluefile & type labels per PPP D135-751-011								

DAS
28
9-09

DAS
28
9-09

5/11/15

1X

JUN 01 2015

B129555

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Item ID: D135-751-011

Accept

N900040100Setup Start ***NS1***

Revision ID:

Item Name: Skidtube with Standard Wearplates Fits LH or RH

Stop ***NS2***Start Date: 2/13/2015 Start Qty: 1.00 ***1***

Cust Item ID:

Required Date: 2/13/2015 Req'd Qty: 1.00 ***1***

Customer:

Reference:

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____
QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Run Start ***NR1***Stop ***NR2***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
120	Skidtubes	0.00							
120									
Skidtubes	Memo	0.00							
Skidtubes	1-Cut Aft end as per dwg D3507								
	2-Deburr ends								
	3-Drill Aft & Fwd Cap holes using DT8678 & DT8901								
	4-Locate DT8870 & Drill Ground wire hole on top of Tube.								
	6-Locate DT8870 with #30 cleco in Ground wire hole ,then Pilot Drill all X-Bolt holes using #30" drill.*****DO NOT OPEN AFT CAP HOLES*****								
	7-Open crossbolt holes to 0.3125" (3 per side). Drill pilot holes for wearplates using Dt8868,Use DT8892 FOR REAR WEARPLATE HOLES.								
	8-Open six rear wearplate holes using DT8892.Open all wearplate holes to 0.297"								
	9-Open ground wire hole .297" section E-E								
	10-Open Aft & Fwd Cap holes using .208" drill.								
	11-Bore out aft end of tube as per Dwg D3507 & Detail "B".								
	12- Section G-G holes must be laid out manually, open to #30.								
	13-Deburr holes.								

BE15-02-24

BE15-02-25

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N900040100Setup Start ***NS1***

Revision ID:

Stop ***NS2***

Item Name: Skidtube with Standard Wearplates Fits LH or RH

Start Date: 2/13/2015 Start Qty: 1.00 ***1***

Cust Item ID:

Required Date: 2/13/2015 Req'd Qty: 1.00 ***1***

Customer:

Reference:

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____

Run Start ***NR1***

QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Stop ***NR2***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
--------------------------------	--------------------------	----------------------	---------	--------	--------------	---------------	---------------	------------------	----------------

140

QC5- Inspect part completeness to step on W/O

0.00

140

QC

Memo

0.00

Quality Control

DAS
03
9-89 15-2-25

150

Chemical Conversion Coat per QSI005 4.1

0.00

150

HandFinish

Memo

0.00

Hand Finishing

1  15-2-25 

160

QC7-Inspect Chemical Conversion Coat

0.00

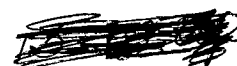
160

QC

Memo

0.00

Quality Control

DAS
18
9-891  15-02-27 

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Item ID: D135-751-011

Accept

N900040100Setup Start ***NS1***

Revision ID:

Stop ***NS2***

Item Name: Skidtube with Standard Wearplates Fits LH or RH

Start Date: 2/13/2015 Start Qty: 1.00 ***1***

Cust Item ID:

Required Date: 2/13/2015 Req'd Qty: 1.00 ***1***

Customer:

Reference:

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____

Run Start ***NR1***

QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Stop ***NR2***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
--------------------------------	--------------------------	----------------------	---------	--------	--------------	---------------	---------------	------------------	----------------

170

0.00

170

Skidtubes

Skidtubes

Memo

0.00

1-Open X-Bolt holes to .375" (1 Places) & .500" (2 Places) as per Dwg D3507.
and section G-G to .750" (2 places)

2-Counter Sink X-BOLT holes as per Dwg D3507

3-Deburr and blow out chips from inside of tube.

4-Bond web as per Dwg D3507 & QSI 015

A/R 241 Sike Flex Batch: 31574
Exp Date: 15-10-21
start time: _____
end time: _____

5-Weld x-bolt spacers as per Dwg D3507 and Detail C-C & D-D and G-G

A/R AL ROD Batch: M130237

6-Grind welds flush

7-Drill Rivet Holes as per Dwg D3507 Using Dt8871A&B

8-Deburr Rivet holes.

BE15-02-27

BE15-03-02

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1 29555

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Accept

N900040100

Setup Start *NS1*

NS2

Item Name: Skidtube with Standard Wearplates Fits LH or RH

Start Date: 2/13/2015 **Start Qty:** 1.00 ***1***

Cust Item ID:

Required Date: 2/13/2015 Req'd Qty: 1.00 * 1 *

Customer:

Reference:

Approvals: **Process Plan:** _____ **Date:** _____ **Tooling:** _____ **Date:** _____

Run Start *NR1*

QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Stop *NR2*

[illegible]

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N900040100

Setup Start *NS1*

Stop *NS2*

Item Name: Skidtube with Standard Wearplates Fits LH or RH

Start Date: 2/13/2015 **Start Qty:** 1.00 ***1***

Cust Item ID:

Required Date: 2/13/2015 Req'd Qty: 1.00 *1*

Customer:

Reference:

Approvals: **Process Plan:** _____ **Date:** _____ **Tooling:** _____ **Date:** _____

Run Start *NR1*

QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Stop ***NR2***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
--------------------------------	--------------------------	----------------------	---------	--------	--------------	---------------	---------------	------------------	----------------

210

Pressure Wash per QSI005 4.3

0.00

210

0.00

HandFinish

Memo

Hand Finishing

Re-alodine tube as per QSI 005 section 4.1.2.1 do not acid etch.

220

0.00

220

0.00

SprayPaint

Memo

Spray Painting

1- Apply Primer as per QSI 005 4.2.1.3.3 and dwg

A/R Primer Batch: 130992

2- Paint two coats of White paint as per QSI 005 4.2 and dwg

A/R Paint Batch: 131599

230

QC14- Inspect Spray Paint

0.00

230

0.00

QC

Memo

Quality Control

**DAS
15
9-89**

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Item ID: D135-751-011

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N900040100Setup Start ***NS1***

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Stop ***NS2***

Item Name: Skidtube with Standard Wearplates Fits LH or RH

Start Date: 2/13/2015 Start Qty: 1.00 ***1***

Cust Item ID:

Required Date: 2/13/2015 Req'd Qty: 1.00 ***1***

Customer:

Reference:

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____

Run Start ***NR1***

QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Stop ***NR2***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
--------------------------------	--------------------------	----------------------	---------	--------	--------------	---------------	---------------	------------------	----------------

260

260

HandFinish

HandFinishing

Memo

0.00

0.00

Hand Finishing

1- Install Wearplate & Ground Wire inserts as per Dwg D3507.

1-Inspect for Foreign objects

2-Install Fwd & Aft caps as per Dwg D3507 And Detail "A" & "B"

A/R 241 Sika Flex Batch: M131574
Exp Date: 1510

3-Install Wearplates as per Dwg D3507,

Note: Install (1) Bolt and (1) washer on Ground Wire insert on top of tube

Do not Install Screws where indicated on Dwg (Note #6)

A/R 241 Sika Flex Batch: M131574
Exp Date: 1211

4-assemble o-ring to plug as per dwg D3492 and apply o-ring lube

A/R 55-o-ring lube batch: M131349 RTU 548 M132017 exp 15/07

5- Wing Walk as per Dwg D3507 and QSI 005 4.4

Batch: M132039

1x 6 4 1510428

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 Revision ID: Stop *NS2*
 Item Name: Skidtube with Standard Wearplates Fits LH or RH
 Start Date: 2/13/2015 Start Qty: 1.00 *1* Cust Item ID:
 Required Date: 2/13/2015 Req'd Qty: 1.00 *1* Customer:
 Reference:

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____ Run Start *NR1*
 QC: _____ Date: _____ SPC (Y/N): _____ Date: _____ Stop *NR2*

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
300		0.00							
300	Packaging								
Packaging	Memo	0.00							
Packaging	Identify and pack for shipping as per PPP D135-751-011								
	Location: <u>SH</u>								
	PPP Rev: _____								
310	QC21- Final Inspection - Work Order Release	0.00							
310									
QC	Memo	0.00							
Quality Control									

JUN 01 2015
 JUN 03 2015
 MLJ
 15-6-2

Picklist Print

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Parent Item: D135-751-011

D135-751-011

Parent Item Name: Skidtube with Standard Wearplates Fits LH or RH

Start Date: 2/13/2015

Required Date: 2/13/2015

Start Qty: 1.00

Required Qty: 1.00

Comments: IPP Rev:A06-06-21New Issue JLM
 IPP Rev:B 06-12-18 As per Rev B JLM
 IPP Rev:C 07-12-11 ECN 1036 as per revB DD
 IPP Rev D 08.11.04 Added DT9431 to sequence 5 EC verf DD IPP Rev E
 10.02.22 per pAR 09-043 EC verified by: DD IPP Rev:F 10.06.09
 remove seq110 DD verf:EC IPP Rev G 10.09.17 added
 D3507-1-bent EC verified by:DD IPP REV:H 13.12.11 ECN13-619/
 CHG002 DD VERF:JLM

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
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ALS7-1032-130	AELS8-1032-130	Purchased	No				Each	6,426.000		38			
---------------	----------------	-----------	----	--	--	--	------	-----------	--	----	--	--	--

AI S7-1032-130

Rivnut

Handwritten: 15/02/28

Location	Loc Qty	Loc Code
CA	6	
M128649	6	
CCK003	6320	
M128649	6320	
FG	100	
121444	100	

Handwritten: x38

D3507-1-BENT	Manufactured	No				120	Each	8.0000	1	1			
--------------	--------------	----	--	--	--	-----	------	--------	---	---	--	--	--

D3507-1-BFNT

Skidtube Assembly EC135

Handwritten: BE 15-02-24

Location	Loc Qty	Loc Code
LG002	8	
<i>(115439)</i>	8	
	170	

D3504-1	Manufactured	No					Each	10.0000	2	2			
---------	--------------	----	--	--	--	--	------	---------	---	---	--	--	--

D3504-1

Crossbolt Spacer

Handwritten: BE 15-03-02

Location	Loc Qty	Loc Code
LG001	10	
<i>(99007)</i>	10	

Handwritten: 2

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Work Order ID: 129555

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Parent Item: D135-751-011

D135-751-011

Parent Item Name: Skidtube with Standard Wearplates Fits LH or RH

Start Date: 2/13/2015

Required Date: 2/13/2015

Start Qty: 1.00

Required Qty: 1.00

D3504-3 Manufactured No

170 Each 60.0000 1 1

D3504-3

Crossbolt Spacer

**

03-02
BE15-02-02

Location

Loc Qty

Loc Code

LG001

60

105604

53

31232

7

1

D3504-5 Manufactured No

170 Each 13.0000 2 2

D3504-5

Crossbolt Spacer

**

BE15-03-02

Location

Loc Qty

Loc Code

LG001

13

106024

13

2

D3505-1 Manufactured No

170 Each 7.0000 1 1

D3505-1

Web

**

BE15-02-27

Location

Loc Qty

Loc Code

LG002

7

112204

7

1

D3506-1 Manufactured No

190 Each 11.0000 4 4

D3506-1

Doubler

**

BE15-03-04

Location

Loc Qty

Loc Code

LG001

11

106261

11

4

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Parent Item: D135-751-011

D135-751-011

Parent Item Name: Skidtube with Standard Wearplates Fits LH or RH

Start Date: 2/13/2015

Required Date: 2/13/2015

Start Qty: 1.00

Required Qty: 1.00

D3506-3 Manufactured No

190 Each 13.0000 2 2

D3506-3

Doubler

**

BB 15-03-04

Location

Loc Qty

Loc Code

LG001

13

51790

13

2

MS20601-AD4W3

Purchased No

190 Each 134.0000 12 12

MS20601-AD4W3

Rivet

**

BE 15-03-04

Location

Loc Qty

Loc Code

ST308

134

114538

18

m131340

116

12

ALS4-1032-225

AELS8-1032-225 Purchased

No

260 Each 163.0000 1 1

ALS4-1032-225

Rivnut

**

11 15/04/25

Location

Loc Qty

Loc Code

FG

120

M127028

120

FP001

43

M131067

43

11 131582

21

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Work Order ID: 129555

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Parent Item: D135-751-011

D135-751-011

Parent Item Name: Skidtube with Standard Wearplates Fits LH or RH

Start Date: 2/13/2015

Required Date: 2/13/2015

Start Qty: 1.00

Required Qty: 1.00

AN3C4A

Purchased

No

260

Each

1,554.000

31

31

AN3C4A

Bolt

ll 15/04/28

Location

Loc Qty

Loc Code

FG

20

122814

20

ST338a

1400

M131320

400

M131420

1000

ST350

134

M130716

134

x31

AN3C5A

Purchased

No

260

Each

1,089.000

2

2

AN3C5A

Bolt

ll 15/04/28

Location

Loc Qty

Loc Code

FG

5

122800

5

ST338a

662

M130770

146

M130851

16

M131320

500

ST350

422

M131420

422

11131803

x2

AN526C1032R10

Purchased

No

260

Each

107.0000

2

2

AN526C1032R10

Screw

ll 15/04/28

Location

Loc Qty

Loc Code

FP001

2

108062

2

ST327

105

m128712

105

x2

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Work Order ID: 129555

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Parent Item: D135-751-011

D135-751-011

Parent Item Name: Skidtube with Standard Wearplates Fits LH or RH

Start Date: 2/13/2015

Required Date: 2/13/2015

Start Qty: 1.00

Required Qty: 1.00

D2965

Manufactured No

260

Each

9.0000

1

1

D2965

Cap

**

all 10/04/28

Location

Loc Qty

Loc Code

FP001

9

99551

9

X1

D2965-3

Manufactured No

260

Each

12.0000

1

1

D2965-3

Cap

**

all 10/04/25

Location

Loc Qty

Loc Code

FP001

12

120969

7

X1

98923

5

D3492-1

Manufactured No

260

Each

188.0000

4

4

D3492-1

Plug

**

all 10/04/28

Location

Loc Qty

Loc Code

FP001

188

M131113

X4

128509

173

129057

15

D3492-3

Manufactured No

260

Each

106.0000

4

4

D3492-3

Plug

**

all 10/04/28

Location

Loc Qty

Loc Code

FP001

106

B131036

X4

125905

2

128476

104

Picklist Print

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Work Order ID: 129555

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Parent Item: D135-751-011

D135-751-011

Parent Item Name: Skidtube with Standard Wearplates Fits LH or RH

Start Date: 2/13/2015

Required Date: 2/13/2015

Start Qty: 1.00

Required Qty: 1.00

D3492-7

Manufactured No

260

Each

104.0000

2

2

D3492-7

Plug

**

ll 13/04/25

Location

Loc Qty

Loc Code

FP001

104

106110

100

86759

4

x2

D4918-047

Manufactured No

260

Each

5.0000

1

1

D4918-047

Wearplate Aft

**

ll 13/04/25

Location

Loc Qty

Loc Code

FP001

4

123667

4

ST609

1

119894

1

B128771

x1

D4918-1

Manufactured No

260

Each

10.0000

1

1

D4918-1

Wearplate Fwd

**

ll 13/04/25

Location

Loc Qty

Loc Code

FP001

8

112525

2

113348

6

FP002

2

119891

2

x1

D4918-3

Manufactured No

260

Each

6.0000

1

1

D4918-3

Wearplate Center Fwd

**

ll 13/04/25

Location

Loc Qty

Loc Code

FP002

6

112352

2

113301

4

?

x1

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Work Order ID: 129555

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Parent Item: D135-751-011

D135-751-011

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Start Date: 2/13/2015

Required Date: 2/13/2015

Start Qty: 1.00

Required Qty: 1.00

D4918-5

Manufactured No

260

Each

12.0000

1

1

D4918-5

Wearplate Center Aft

all 12/64/25

Location

Loc Qty

Loc Code

FP002

12

112548

4

113349

3

115162

4

119893

1

x1

NAS1149C0332R

Purchased No

260

Each

3,891.000

33

33

NAS1149C0332R

WASHER

all 15/64/28

Location

Loc Qty

Loc Code

FP001

2140

m130325

2140

M131697

x33

GA

2

125654

2

ST271

1749

125654

44

m130466

15

m131340

1690

x33

NAS1611-007

Purchased No

260

Each

346.0000

2

2

NAS1611-007

O-RING

all 15/64/28

Location

Loc Qty

Loc Code

FP001

346

103697

346

x2

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Parent Item: D135-751-011

D135-751-011

Parent Item Name: Skidtube with Standard Wearplates Fits LH or RH

Start Date: 2/13/2015

Required Date: 2/13/2015

Start Qty: 1.00

Required Qty: 1.00

NAS1611-010

Purchased

No

260

Each

132.0000

4

4

NAS1611-010

O-RING

all 15/04/28

Location

Loc Qty

Loc Code

FP001

132

1131770

m130797

4

m131329

128

NAS1611-013

Purchased

No

260

Each

710.0000

4

4

NAS1611-013

O-RING

all 15/04/28

Location

Loc Qty

Loc Code

FP001

710

m130758

710

AN3C4A

Purchased

No

280

Each

1,554.000

8

AN3C4A

Bolt

DAS
6
9-89

Location

Loc Qty

Loc Code

FG

20

122814

20

ST338a

1400

M131320

400

M131420

1000

ST350

134

M130716

134

D3512-041

Manufactured

No

280

Each

1.0000

2

2

D3512-041

Wearplate

DAS
28
9-89

Location

Loc Qty

Loc Code

st612

1

125607

1

DAS
28
9-89

B131477

2

DAS
27
9-89

MAY 28 2015

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Parent Item: D135-751-011

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Parent Item Name: Skidtube with Standard Wearplates Fits LH or RH

Start Date: 2/13/2015

Required Date: 2/13/2015

Start Qty: 1.00

Required Qty: 1.00

NAS1149C0332R

Purchased

No

280

Each

3,891.000

8

8

NAS1149C0332R

MAY 27 2015

WASHER

Location

Loc Qty

Loc Code

FP001

2140

m130325

2140

GA

2

125654

2

ST271

1749

125654

44

m130466

15

m131340

1690

**DAS
28
9-89**

**DAS
6
9-89**

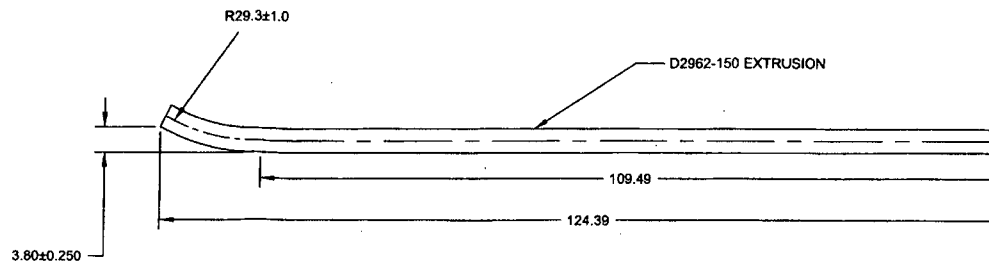
MBK97

8

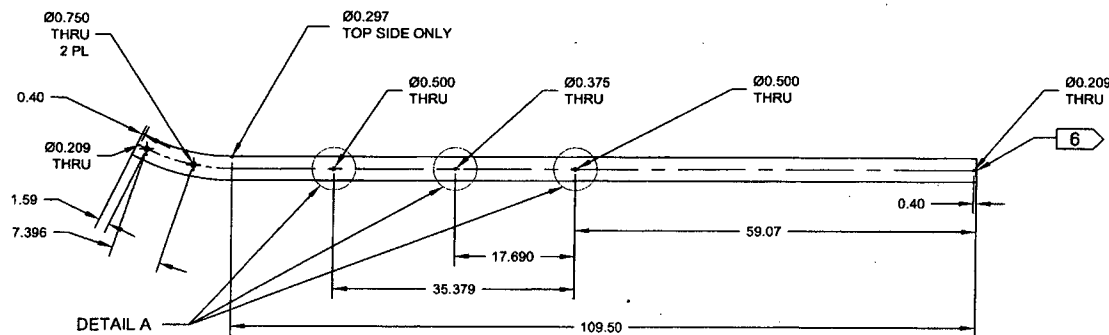
Qty	Part Number	Description
X	D3507-041	SKIDTUBE ASSEMBLY
1	D2962-150	EXTRUSION
1	D2965	CAP
1	D2965-3	CAP
4	D3492-041	PLUG ASSEMBLY
4	D3492-043	PLUG ASSEMBLY
2	D3492-047	PLUG ASSEMBLY
2	D3504-1	CROSS BOLT SPACER
1	D3504-3	CROSS BOLT SPACER
2	D3504-5	CROSS BOLT SPACER
1	D3505-1	WEB
4	D3506-1	DOUBLER
2	D3506-3	DOUBLER
1	D4918-1	WEARPLATE
1	D4918-3	WEARPLATE
1	D4918-5	WEARPLATE
1	D4918-047	WEARPLATE
38	AELS-1032-130	INSERT
1	AELS-1032-225	INSERT
31	AN3C4A	BOLT
2	AN3C5A	BOLT
2	AN526C1032-10	SCREW
33	AN960C10L	WASHER
12	MS20601AD4W3	RIVET

GENERAL NOTES:

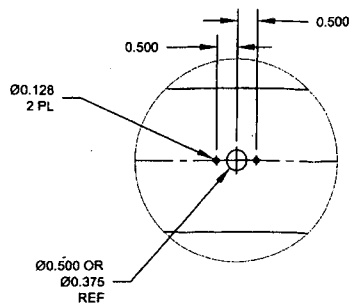
- 1) MATERIAL: N/A
- 2) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1 PRIOR TO INSERTING D3505-1 WEB.
STANDARD: PRIME (REF. 4.2.1.3.3) AND PAINT WHITE PER DART QSI 005 4.2.
OPTIONAL: POWDER COAT WHITE (REF. 4.3.5.1) PER DART QSI 005 4.3.
BLACK ANTI-SKID PAINT AS INDICATED TO 1.00 ABOVE CENTERLINE PER DART QSI 005 4.4 (OPTIONAL).
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) DIMENSIONS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: IDENTIFY WITH DART B/N PER DART QSI 044 6.4 (VIBRATING STYLUS) ON I.D. OF TUBE.
- 7) WEIGHT: 24.1 LB (FROM IIN-D135-751)
- 8) WELDING TO BE DONE PER DART QSI 004
- 9) INSERT D3505-1 WEB TO LOCATION SHOWN OFF AFT END OF SKIDTUBE AND BOND WEB INTO OUTER TUBE WITH NON-STRUCTURAL SIKAFLEX-2411/291 ADHESIVE PER DART QSI 015 AFTER BENDING
- 10) USE DART DRILL TEMPLATE DT8868 TO LOCATE AND DRILL Ø0.297 HOLES (38 PLACES) FOR WEARSHOE INSERTS. INSTALL AELS-1032-130 PER SECTION C-C (38 PLACES) AFTER FINISH. SEAL WEARPLATE BOLTS WITH SIKAFLEX-2411/291.
- 11) DO NOT INSTALL AN3C4A BOLTS AND AN960C10L WASHERS IN INDICATED LOCATIONS



D3507-1 BENDING/CUTTING DETAIL

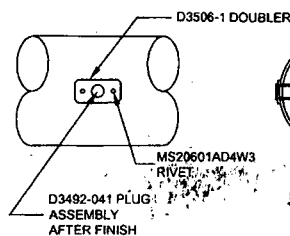


D3507-1 DRILLING DETAIL



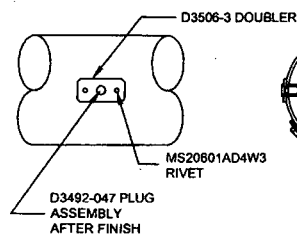
DETAIL A
TYP, 6 PL
SCALE 3:10

D	REMOVE D3558-X GASKETS, D4918-X WAS D3508-X REVISE FINISH TO ADD PAINT AS THE PREFERRED FINISH. REVISED NOTES	DW	13.08.30
C	ADD D3504-5, FOR SKID GEAR DEFLECTOR; CHANGE FWD CAP BOLT TO AN526C1032-10 SCREW	DC	07.09.19
B	ADD GASKET, CHANGE HARDWARE MATL	PH	06.11.01
A	NEW ISSUE	PH	06.04.21
REV.	DESCRIPTION	BY	DATE
DESIGN	DW	DART AEROSPACE USA, INC KENT, WA	
DRAWN	DW		
CHECKED	JP	DRAWING NO.	REV. D
MFG. APPR.	JP	D3507	SHEET 1 OF 2
APPROVED	JP	TITLE	SCALE
DE APPR.	JP	EC 135 SKIDTUBE	NTS
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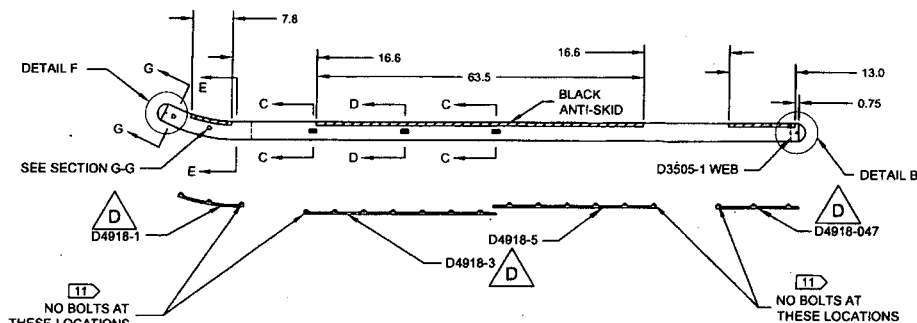
SECTION C-C
(SCALE 3:10)

- D3504-1 CROSS BOLT SPACER**
- AFTER BENDING AND DRILLING ASSEMBLY PERFORM THE FOLLOWING FOR Ø0.500 HOLES ONLY:
1. CHAMFER HOLE 0.030 x 45°
 2. INSERT D3504-1 CROSS BOLT SPACER 2 PL
 3. WELD INTO PLACE AND GRIND FLUSH
 4. IF REQUIRED, PASS Ø0.404 (Y" DRILL) THRU HOLE
 5. INSTALL D3506-1 DOUBLER 4 PL USING MS20601AD4W3 RIVET 8 PL
 6. AFTER FINISH, INSTALL D3492-041 PLUG ASSEMBLY 4 PL

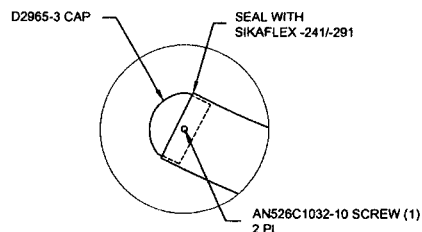


SECTION D-D
(SCALE 3:10)

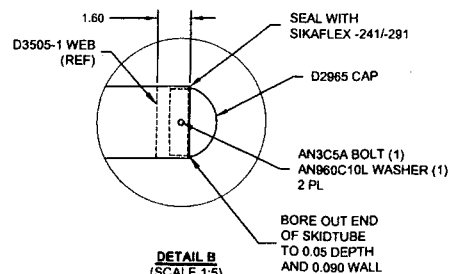
- D3504-3 CROSS BOLT SPACER**
- AFTER BENDING AND DRILLING ASSEMBLY PERFORM THE FOLLOWING FOR Ø0.375 HOLES ONLY:
1. CHAMFER HOLE 0.030 x 45°
 2. INSERT D3504-3 CROSS BOLT SPACER 1 PL
 3. WELD INTO PLACE AND GRIND FLUSH
 4. IF REQUIRED, PASS Ø0.277 (J" DRILL) THRU HOLE
 5. INSTALL D3506-3 DOUBLER 2 PL USING MS20601AD4W3 RIVET 4 PL
 6. AFTER FINISH, INSTALL D3492-047 PLUG ASSEMBLY 2 PL



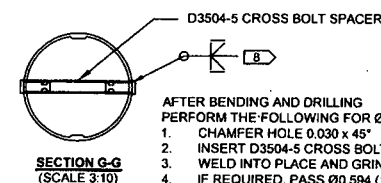
D3507-041 ASSEMBLY DETAIL



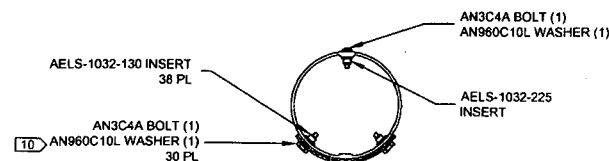
DETAIL F
(SCALE 1:5)



DETAIL B
(SCALE 1:5)



- AFTER BENDING AND DRILLING ASSEMBLY PERFORM THE FOLLOWING FOR Ø0.750 HOLES ONLY:
1. CHAMFER HOLE 0.030 x 45°
 2. INSERT D3504-5 CROSS BOLT SPACER 2 PL
 3. WELD INTO PLACE AND GRIND FLUSH
 4. IF REQUIRED, PASS Ø0.594 (19/32 DRILL) THRU HOLE
 5. AFTER FINISH, INSTALL D3492-043 PLUG ASSEMBLY 4 PL



SECTION E-E
(SCALE 3:10)

DESIGN	DW	DART AEROSPACE USA, INC	
DRAWN	DW	KENT, WA	
CHECKED	GP	DRAWING NO.	REV. D
MFG. APPR.	GP	D3507	SHEET 2 OF 2
APPROVED	GP	TITLE	SCALE
DE APPR.	GP	EC 135 SKIDTUBE	NTS
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RELEASED
2013-12-10

DART SERVICE INSTRUCTION

TO AMEND INSTALLATION INSTRUCTIONS IIN-D135-751 REV. C
AND INSTRUCTIONS FOR CONTINUED AIRWORTHINESS ICA-D135-751 REV. 2

REF. FAA STC: SR01709SE

REF. EASA STC: EASA.IM.R.S.01278

PURPOSE:

THE D135-751-043 WEARPLATE KIT AT CHG 002 CONTAINS WEARPLATES WITH AN IMPROVED WEAR PATTERN AND A COATING THAT ELIMINATES THE NEED FOR THE RUBBER GASKETS. THE D135-751-011 SKIDTUBE INSTALLATION AT CHG 002 AND D135-751-041 REPLACEMENT SKIDTUBE AT CHG 002 CONTAIN THE NEW WEARPLATES.

THE DSI 9661-011 WEARPLATE UPGRADE KIT IS AVAILABLE TO UPGRADE EXISTING D135-751-011 KITS AT CHG 001 WITH IMPROVED AFT WEARPLATES.

CHANGE:

FOR D135-751-011/-041/-043 KITS AT CHG 002, THE WEARPLATE INSTALLATION PROCEDURE OF ICA-D135-751 SECTION 32.3 IS REVISED AS FOLLOWS. IF INSTALLING THE DSI 9661-011 WEARPLATE UPGRADE KIT, THE PARTS SHOULD BE INSTALLED USING THE FOLLOWING INSTRUCTION.

32.3 WEARPLATE REPLACEMENT

IF REINSTALLING D3508-X WEARPLATES ON D135-751-011/-041 KITS AT CHG 001, THE WEARPLATES SHOULD BE INSTALLED WITH D3558-X GASKETS PER ICA-D135-751 REV. 2. FOR D135-751-011/-041/-043 KITS AT CHG 002, THE WEARPLATES SHOULD BE INSTALLED WITHOUT GASKETS, AS INDICATED BELOW. IF D4918-X WEARPLATES ARE BEING INSTALLED ON D135-751-011/-041 SKIDTUBES AT CHG 001, THEY SHOULD LIKEWISE BE INSTALLED WITHOUT GASKETS AS INDICATED BELOW.

32.3.1 REMOVE WEARPLATES AND GASKETS (IF PRESENT) BY REMOVING THE AN3C BOLTS THAT SECURE THEM TO THE BOTTOM OF THE SKIDTUBE.

32.3.2 CHECK FOR CORROSION AND MECHANICAL DAMAGE IN ACCORDANCE TO CHAPTER 5 AND REPAIR AS REQUIRED. REFINISH BOTTOM OF SKIDTUBE PER CHAPTER 5 OF ICA-D135-751.

32.3.3 INSTALL REPLACEMENT D4918-1/-3/-5/-047 WEARPLATES USING AN3C BOLTS AS APPLICABLE AS SHOWN IN FIGURE 1 OF THIS SERVICE INSTALLATION. INSTALL (QTY 2) D3512-041 WEARPLATES (ITEM 27) OVER FWD AND AFT CLAMPS AS SHOWN IN FIGURE 1 USING AN3C BOLTS AND AN960C10L WASHERS. TORQUE BOLTS 15-25 IN-LB (1.7-2.8 N-m). SEAL WEARPLATE INSERTS USING SIKAFLEX-241/-291 OR PROSEAL 890 MIL-S-8802 CLASS B2 SEALANT.

WEIGHT AND BALANCE:

USE THE FOLLOWING WEIGHT AND BALANCE INFORMATION FOR DART D135-751-011 SKIDTUBE INSTALLATION AT CHG 002.

INSTALLATION	WEIGHT	LATERAL		LONGITUDINAL	
		ARM	MOMENT	ARM	MOMENT
D135-751-011 CHG 002 Skidtube Installation	24.5 lb 11.2 kg	±39.4 in ±1.0 m	±966 in-lb ±11.2 m-kG	147.1 in 3.7 m	3604 in-lb 41.5 m-kG

A	NEW ISSUE	DW	13.08.21
REV.	DESCRIPTION	BY	DATE
DESIGN	DW	DART AEROSPACE USA, INC KENT, WA	
DRAWN	DW		
CHECKED	<i>UP</i>	DRAWING NO.	REV. A
MFG. APPR.	<i>N/A</i>	DSI 9661	SHEET 1 OF 3
APPROVED	<i>[Signature]</i>	TITLE	SCALE
DE APPR.	<i>[Signature]</i>	REVISED WEARPLATE KIT	NTS
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PARTS LIST:

THE PARTS LISTS IN SECTION 32.9 OF ICA-D135-751 (PAGE 35) AND SECTION 5.0 OF IIN-D135-751 (PAGE 11) ARE AMENDED AS FOLLOWS FOR D135-751-011 @ CHG 002 AND LATER.

32.9 PARTS LIST (ICA-D135-751)**5.0 PARTS LIST (IIN-D135-751)**

Item	QTY -011	QTY -041	QTY -043	PART NUMBER	DESCRIPTION
	X			D135-751-011	SKIDTUBE INSTALLATION
	1	X		D135-751-041	REPLACEMENT SKIDTUBE
			X	D135-751-043	WEARPLATE KIT

IS:

20A	1		1	D4918-1	WEARPLATE (REPLACES D3508-1)
21A	1		1	D4918-3	WEARPLATE (REPLACES D3508-3)
22A	1		1	D4918-5	WEARPLATE (REPLACES D3508-5)
23A	1		1	D4918-047	WEARPLATE (REPLACES D3508-7)
27	2		2	D3512-041	WEARPLATE (REPLACES D3512-1)

WAS:

20A	1		1	D3508-1	WEARPLATE
20B	1		1	D3558-1	GASKET
21A	1		1	D3508-3	WEARPLATE
21B	1		1	D3558-3	GASKET
22A	1		1	D3508-5	WEARPLATE
22B	1		1	D3558-5	GASKET
23A	1		1	D3508-7	WEARPLATE
23B	1		1	D3558-7	GASKET
27	2		2	D3512-1	WEARPLATE

THE PARTS LIST FOR THE DSI 9661-011 KIT IS AS FOLLOWS:

QTY -011	PART NUMBER	DESCRIPTION
X	DSI 9661-011	WEARPLATE UPGRADE KIT
1	D4918-047	WEARPLATE
2	D3512-041	WEARPLATE

DESIGN	DW	DART AEROSPACE USA, INC KENT, WA	
DRAWN	DW		
CHECKED	<i>OP</i>	DRAWING NO.	REV. A
MFG. APPR.	<i>N/A</i>	DSI 9661	SHEET 2 OF 3
APPROVED	<i>[Signature]</i>	TITLE	SCALE
DE APPR.	<i>[Signature]</i>	REVISED WEARPLATE KIT	NTS
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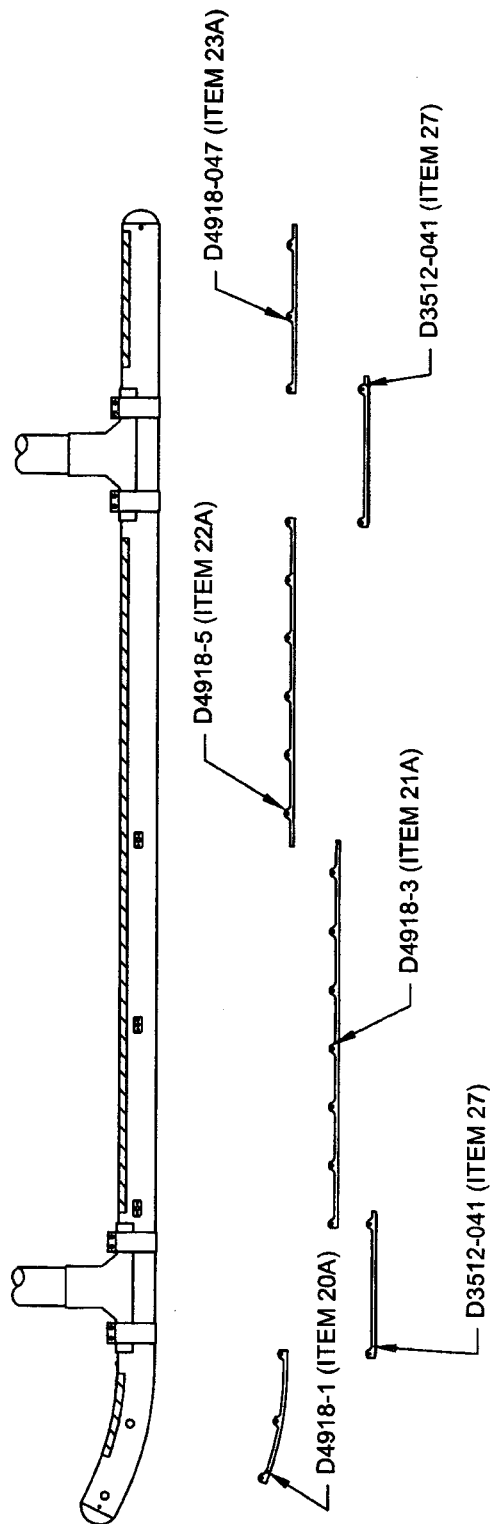


FIGURE 1: WEARPLATE INSTALLATION

DESIGN	DW	DART AEROSPACE USA, INC KENT, WA	
DRAWN	DW		
CHECKED	<i>CP</i>	DRAWING NO.	REV. A
MFG. APPR.	<i>N/A</i>	DSI 9661	SHEET 3 OF 3
APPROVED	<i>[Signature]</i>	TITLE	SCALE
DE APPR.	<i>[Signature]</i>	REVISED WEARPLATE KIT	NTS
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